

Work Order ID 86133

86133

Page 1

June-21-12 8:36:48 AM

Item ID: D3778-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 21/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/12

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3778	B								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3778

5057 090

Dwg Rev: 13

Prog Rev: 2

****grain direction along 2.34" **** ✓

2-Deburr if necessary

6 0 Jm 12-6-23

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

6 0 Jm 12-6-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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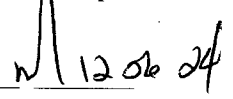
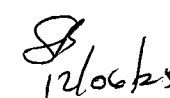
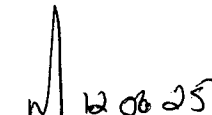
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				6			 12/06/24
130 *130* Brake NC Brake NC	Bend as per dwg NC BRAKE Memo	0.00 0.00				6			 12/06/25
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				6			 12/06/25

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Work Order ID 86133

June-21-12 8:36:48 AM

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Item ID: D3778-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 21/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00				6	76	126-25	
Hand Finishing									
155	QC7-Inspect Chemical Conversion Coat	0.00							
155									
QC	Memo	0.00				6	6	12-7-3	
Quality Control									
160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 8:15								
	OVEN TEMPERATURE: 320 °F								
	FINISH TIME: 8:45								

M121279

6X Ø M.F. 12/07/03

W/O:		WORK ORDER CHANGES					
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86133

Page 4

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

6

6

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

0.00

Quality Control

Identify as per dwg & Stock Location	0.00
--------------------------------------	------

0.00

Packaging

QC21- Final Inspection - Work Order Release	0.00
---	------

0.00

Quality Control

12/7/44
mf
12-09-03

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

June-21-12 8:36:51 AM

Page 1

Work Order ID: 86133

86133

Parent Item: D3778-1

D3778-1

Parent Item Name: Bracket

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A new issue 08-04-15 DD verified by:EC
 IPP Rev:B 08-05-14 revA as per ECN1171 DD verified by:EC
 IPP Rev:C 08-05-22 add powder coating DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M5052H32S.090

Purchased

No

100

sf

53.2800

0.0934

0.589895

**

M5052H32S 090

5052-H32 .090 Sheet

Jun 12-6-23

Location

Loc Qty

Loc Code

MAT022

53.28

118641

11.22

121780

32

3019

10.06

3019

W/O:		WORK ORDER CHANGES					
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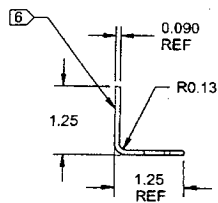
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

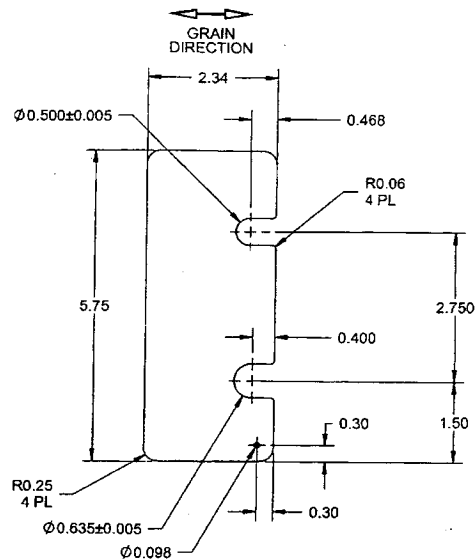
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NOTE: Date & initial all entries



D3778-1 BRACKET



D3778-1F FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 86133 MLJ
12/06/21

RELEASED
2012-03-30

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.090 THICK PER AMS-QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32.090)
OR
6061-T6/T62 ALUMINUM SHEET, 0.090 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T60.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3778-X" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT -1: 0.11 lbs
-3: 0.17 lbs

B	ADDED -3 (REF: PAR 12-163)	AJS	12.03.15
A	NEW ISSUE	PH	08.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3778	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	12.03.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER REASON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

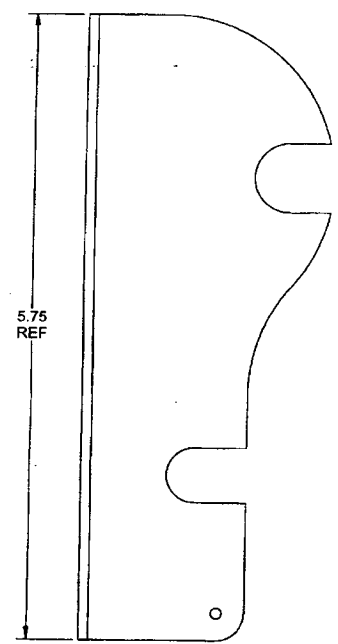
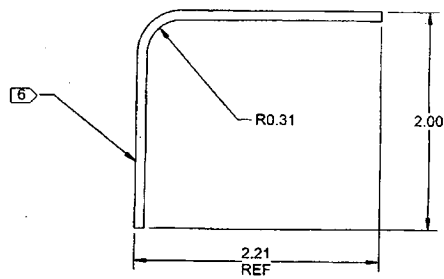
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

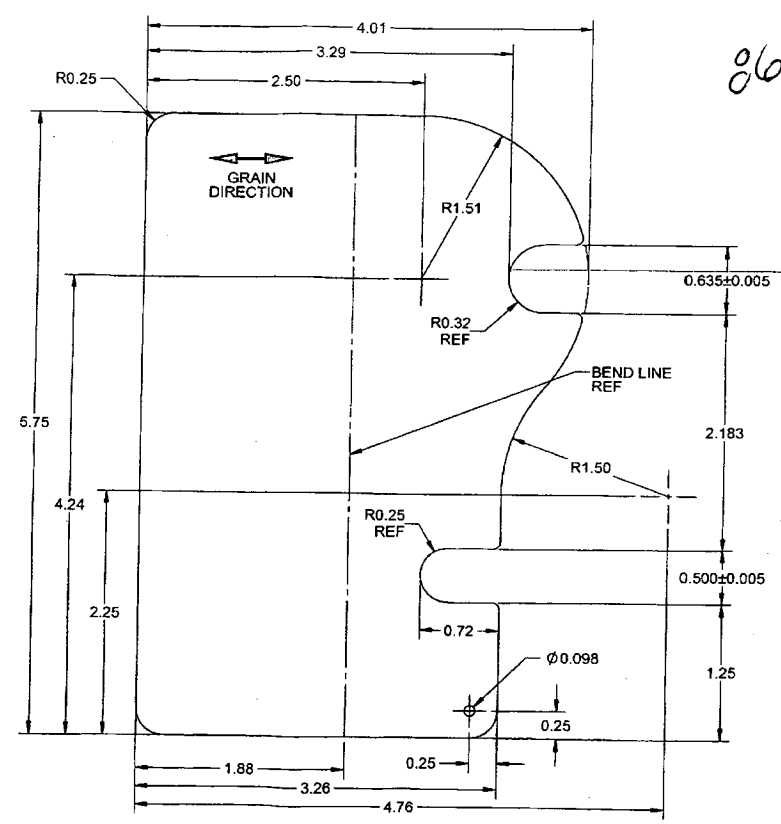
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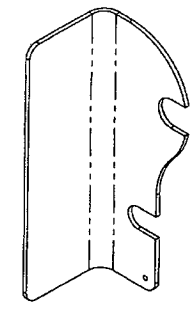
NOTE: Date & initial all entries



D3778-3 BRACKET



D3778-3F BRACKET
(FLAT PATTERN)



RELEASED
2012-03-30

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3778	REV. B
MFG. APPR.		TITLE BRACKET	SHEET 2 OF 2
APPROVED			SCALE
DE APPR.			NTS
DATE	12.03.15	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS RETURNED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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